											DQA:	Date	•
NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	CO	NFORM	MANCE / UP	DATE			
								<b>—</b>			QA Closed:	Date	:
Work Orde	٥٢٠					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG	EI.					Rework	٦		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•	<del></del>				Use-as-is		Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR 1	No.					Work Order Update	pdate Large Fab Composite		]	Supplier			
Root					Descri	otion of work order update	T	Initial	Act	ion	Sign &		
Cause	]	Date	Step	Qty		or Non-conformance	Cł	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling	Ш						İ	į					
Operator	Ш												
Material	Ш												
Setup													
Other													!
Process													
Supplier													
Training												<u> </u>	
Unapproved			1										
-							FAUI	T CATE	GORY				
Landi	ng C	ear				General			·		_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to O	/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	Г	Inspecti	on Incomplete		Part Incorre	ct	Weld
	П	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/L	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved	_	
		Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	Surge	Other
		Ripples in	n Bend			Drill Holes		Offset		<u> </u>	-	_	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

				4	- a	·	
<b>Work Ord</b> <i>May-13-13 1:1</i>			-	*101	715*		Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date:	D3208-7 Filler 5/16/13 : 5/31/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		*N90004010  Cust Item ID: Customer:	Setup Start Stop	*NS1* *NS2*
Reference: Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):	Date:	Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I 130 *130* HandFinish Hand Finishing	ID	Operation Description Chemical Conversion Co	oat per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID Tool # Plan Code	<del>-</del>	teject Insp. Number Stamp
140 *140* QC Quality Control		QC7-Inspect Chemical (	Conversion Coat	0.00	- 1 1 !	15	(\frac{\fin}}}}{\fint}}}}}}}}{\frac{\fir\f{\fir}}{\figna}}}}{\frac{\f{\frac{\frac{\frac{\frac{\frac{\frac{\frac{\fr
150 *150* Packaging Packaging		Identify as per dwg & St	tock Location: <u>572</u> C	0.00		_/5½	M. D. 13-08-7
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											DQA.		ate.	
NCR: Y	es /	No				WORK ORDER NON-	COI	NFORI	MANCE / UPDATE		QA Closed:		ate:	
NA Condi						DISPOSITION			AGA	INST DE	PARTMENT	/PROCESS		
Work Orde						Rework Scrap	1		Skid-tube Cross  Machining Small		Pro	Water Jet d. Eng. Coor.	$\boldsymbol{\vdash}$	Engineering Quality
NCR No.					Use-as-is Work Order Update		1	noforming Finis Large Fab Compo	~ ,	Rec/Sto	re/Packaging Supplier	$\blacksquare$	Other	
Root					Descri	ption of work order update		Initial	Action		Sign &	·		
Cause	[	ate	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	on	QC Inspector
Doc/Data						. <u>.</u>	Π		-		-			
Equip/Tooling														
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Material				İ									i	
Setup -														
Other *														
Process														
Supplier							İ							
Training					ŀ									
Unapproved					<u> </u>		<u> </u>							
					-	F	AUI	LT CATE	GORY		<u> </u>			
Landi	ng Gea	r			_	General	_	7		_	7			
	Bei	nding				Bend		Grain			Ovalized			Pressure/Forced
	Ce	ntre No	t Conce	ntric to	o/s	BOM/Route	$\perp$	Hardwa		<u> </u>	Over/Under			Temperature/Cure
	Cracks				<u> </u>	Broken/Damaged	L	-	on Incomplete		Part Incorre		-	Weld
	Crushed/Crimped				L.	Burrs	L	-{	ions Incomplete/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	∐ Cu	ffs			<u> </u>	Contamination	$\perp$	Mainte	nance		Part Moved			
[	Heat Treat					Countersink	1	Mislabe	led		Positioned V	Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Cut Too Short Drill Holes

Drawing

Finish Folio Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

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		01715	. <del>-</del>	*101	715*		-				Page 3
Item ID: Revision ID: Item Name:	D3208-7		=	Accept	*N900	)040 <i>′</i>			tup Start Stop	1/4	S1* S2*
Start Date: Required Date Reference:	5/16/13 e: 5/31/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item Customer:				<b>~</b>		
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):	<b>T</b>	eate:		Ri	in Start Stop	" <b>I</b> VI	R1* R2*
Sequence ID/ Work Center		Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID		Plan Code	Accept Qty		Reject Number	Insp. Stamp
*160* QC Quality Control		Memo		0.00				M			8-08 08-03

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										DQA:	Date:			
NCR: Y	⁄es	/ No				WORK ORDER NON-C	ONFORI	MANCE / UP	DATE	QA Closed:	Date:			
Work Orde	er: _									ST DEPARTMENT/PROCESS				
Part N	No				<del></del>	Rework Scrap Use-as-is		Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR No.						Work Order Update		Large Fab	Composite	]	Supplier			
Root					Descri	ption of work order update	Initial	Ac	tion	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector		
Doc/Data														
Equip/Tooling			<b>!</b>	•										
Operator														
Material			ĺ									1		
Setup														
Other			1		ļ					1				

## **FAULT CATEGORY Landing Gear** General Pressure/Forced Bending Bend Grain Ovalized BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Part Incorrect Weld Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Part Lost/Missing Crushed/Crimped Instructions Incomplete/Unclear Burrs Part Moved Cuffs Maintenance Contamination Mislabeled Positioned Wrong Heat Treat Countersink Other Inspection Strip in Tube Misread Power Loss/Surge Cut Too Short Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence

Outside Dimensions

Wave/Twist in Tube

Folio

Process
Supplier
Training
Unapproved

May-13-13 1:12:34 PM

Work Order ID:

101715

Parent Item:

D3208-7

Parent Item Name:

Filler

Start Date: 5/16/13

Required Date: 5/31/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP REV C:PER REV B 12-03-23

IPP: B04.05.25Material changed for Step 4KJ/JLM IPP REV C:PER REV E JLM VERIFIED BY:EC IPP REV:D 12.04.20 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item II)	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route   Seq 1D	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet	<del></del> -	Purchased	No	- · <u>-</u>			sf	111.0973	. = 7	0.9494 <del>7</del> 4 ).			
				<b>Location</b>		Loc Oty	<u>Lo</u>	c Code					
				MAT021		111.097264							
				117	285	0.497264			<del></del>				
				124	786	110.6							
				_					(26	309			

126309

											DQA:	Dat	:e:	
NCR: Y	⁄es	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UPDATE					
											QA Closed:	Dat	:e:	
Work Orde	o r ·					DISPOSITION			AGA	INST DE	PARTMENT	/PROCESS		
WOIK OILL	EI.				<del>.</del>	Rework	7		Skid-tube Cross	stube	1	Water Jet	$\neg$	Engineering
Part N	۷o.					Scrap	1	l ,	<b>⊢</b> ⊸l	Il Fab	Pro	d. Eng. Coor.	┥.	Quality
		· · ·				Use-as-is	1		~ <b>—</b>	shing	-1	re/Packaging	┨	Other
NCR N	No.					Work Order Update	1	]	~ <b>—</b> —	osite	1	Supplier	$\neg$	
,											-		_	
Root					Descri	iption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Description		Date	Verification	丄	QC Inspector
Doc/Data			1				1					ļ		
Equip/Tooling							1					]		
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Material	L				]									
Setup	L				1						1		- 1	
Other	L		ļ	]								i		
Process	dash		1	]		•								
Supplier	_			İ								ļ	ı	
Training	L						ì				İ			
Unapproved			<u> </u>	<u></u>			- 0 1 11	LT CATE	SORV.		<u> </u>	<b>L</b> .		
Landii	na (					General	AUI	LICATE	GURT		<u> </u>			
Canun		Bending			Г	Bend		Grain		Γ.	Ovalized	Г		ressure/Forced
	┝	•	nt Concer	atric to	0/5	BOM/Route	$\vdash$	Hardwa	ro	<u></u>	Over/Under	tolerance	_	emperature/Cure
	Centre Not Concentric to O/S Cracks				Broken/Damaged	$\vdash$	┥	on Incomplete		Part Incorre	<b>-</b>		/eld	
	⊢	Crushed/	Crimped			Burrs		<b>⊣</b> `	ions Incomplete/Unclear	<u> </u>	Part Lost/M	F		rong Stock Pulled
	$\vdash$	Cuffs	<b></b>			Contamination	$\vdash$	Mainte	·		Part Moved	· .		•

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	101715
Description: Filler	Part Number:	D3208-7
Inspection Dwg: D3208 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

FIRST ARTICLE INSPECTION CHECKLIST										
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments				
Ø0.098	+0.005/-0.001	0.100			U	Jamos				
2.90	+/-0.030	2.904"	-		V	, , , , , , , , , , , , , , , , , , ,				
3.95	+/-0.030	3.956"	_		V					
0.13	+/-0.030	0.137	-		V					
0.080	+/-0.010	0.079"	-		V					
			·							
				- :						
		·								

			709			
Measured by:	Jm	Audited by:	457U	Prelim	inary Approval:	
Date:	13-07-21	Date:	13 7 00		Date:	
	•				··· <del>······</del>	

Rev	Date	Change	Revisediby	Approved
_ A	12.05.22	New Issue	KJ OX	1/1
			<del></del>	



